Work Ord September-11-1				*124	1211*			4	:			Pag	ge 1
Item ID: Revision ID: Item Name:	D3512-1 Stainless Ste	eel Wearplate		Accept	*N900	040	100	ገ*	Setup	Start Stop	*N	S1*	
Start Date: Required Date: Reference:	9/10/14 9/10/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1 Customer:	ID:				ı		( )/	
Approvals:	Process P	lan: MUゴ	Date: 14-09-	12 Tooling:	D	ate:			Run	Start	*N	R1*	t
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*	<b>t</b>
Sequence ID/ Work Center II	D	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	<del></del>
Draw Nbr	Re	vision Nbr							~~			эшир	
D3512	D							•					
*100		FLOW WATER JET		0.00	÷			19				DAS 23	 14-09-1
Waterjet FLOW CNC Waterje	et	<b>Memo</b> 1-Cut as pe	r Dwg D3512	0.00								9-89	1-10
·		Dwg Rev:_ Prog Rev:_		,									
		2-Deburr if	necessary										
*110		QC2- Inspect parts off m	achine FAI/FAIB	0.00				12	ı .			DAS 23 (	// AG-76
QC		Memo		0.00					<u> </u>			9-89	4-09-26

0.00

Memo

Quality Control

DQA:			Date:											-	DART
OA Classel			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UF		Mark A	rder un	date only	_	AEROSPACE
QA Closed:			Date.	<del></del>											
Work Orde	or.					DISPOSITION				AGAINST [	DEPART	MENT	/PROCESS		
WOIR Old	-''-		-			Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1		noforming	Finishing	R	ec/Stor	e/Packaging		Other
NCR I	No.					Suspected Unapproved	1		Large Fab	Composite			Supplier[		
	•						•								
Root					Desc	ription of work order update	1	Initial	Acti		1 1	gn &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	D	ate	Verification	1	QC Inspector
Design														-	
Doc/Data							-								
Equip/Tooling	Ш		:						· -						
Handling/Pre						,									
Material															
Operator													:	- 1	
Offset/Setup															
Process	Ц														
Supplier	ш													- [	
Training			}												
Transport							1								
Unapproved	_			<u> </u>	l										
			_				FA	ULT CA	TEGORY	- mvu-					••
Landi						General	_	] /5		Г		سام داد:	ensions	П,	Pressure/Forced
		Bending			<u> </u>	Bend	-	4	Program	ŀ			tolerance	-	Set-up
	71.	Centre N	ot Concei	ntric	,	BOM/Route	$\vdash$	Grain		}		Incorre		-	Temperature/Cure
	-	Cracks	. 1. (5) 1.		·  -	Broken/Damage/Defect	$\vdash$	Hardwa		auglified		Lost/Mi			Weld
		Crimp/Ki	nk/Ripple	e/Wave	<u> </u>	Burrs	-	4 '	ion Incomplete/Un	· F	_	Moved	issiiig	$\vdash$	Wrong Stock Pulled
		Cuffs			$\vdash$	Countarion	$\vdash$	- 4	tions Incomplete/U gned/off center	nicieai	_	tioned V	Vrong	Ш'	varong stock runeu
	<u> </u>	Crushing			-	Countersink	-	Mislabe			_	er Loss/	-		Other
	-	Heat Trea		Tuba	$\vdash$	Cut Too Short	$\vdash$	Misrea		L		C1 LU33/	Juige	L1 <u>`</u>	<u> </u>
[	_	Inspectio	•	i iupe	<u> </u>	Drawing		Off-set							
	-	Marks/Cl			-	Drill Holes Finish	-	┥	Calibration			-		_	
	-	Turning S			$\vdash$	Fit/Function	$\vdash$	┥	Sequence					-	
1	1	Wave/Tv	vist in Tul	ne	- 1	ן דוע דעווכנוטוו ,	1	Jour of .	sequence	V.					

Work Orde September-11-1				*124	1211*					di verra di di	Page	2
Item ID: Revision ID:	D3512-1			Accept	*N900	<u>0401</u>	<b>)</b> /)*	Setuj	Start	*N	S1*	
Item Name:	Stainless Steel	Wearplate			•				Stop	<b>*N</b> I	S2*	
Start Date: Required Date: Reference:	9/10/14 9/10/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item l Customer:	ID:						
Approvals:	Process Plan	n: _ ,	Date:	Tooling:	D:	ate:		Run	Start	~1/1	R1*	
	QC:		Date:	SPC (Y/N):	D:	ate:	<del></del>		Stop	*NI	R2*	
Sequence ID/ Work Center II	)	Operation Description QC8- Inspect parts - seco	and about	Set Up/ Run Hours	Tool ID	Tool # Pla		ot Re Qt		Reject Number	Insp. Stamp DAS	
*120* QC Quality Control		Memo	ond check	0.00			R	2_	<del></del>		38 9-89	149-0
								1				
<sup>130</sup> *130*		NC BRAKE		0.00		DAS	. 4				٨	4 ah
Brake NC Brake NC		<b>Memo</b> Deburr if nec	cessary	0.00		<b>30</b> 9-89	12	<u> </u>				(( ()
		Form as per of	dwg D3512 using DT81	79								

0.00

0.00

140

\*140\*

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

DQA:			Date:										70	ΔRT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				A E	ROSPACE
QA Closed:			Date:								Work Order u	odate only		
Work Orde	ır.					DISPOSITION				AGAINST [	DEPARTMENT	/PROCESS		
WOIK OIGE	-					Rework			Skid-tube	Crosstube		Water Jet	Engine	ering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		uality
	•		*		_	Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	ю.					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n QC Ir	rspector
Design														
Doc/Data											İ			
Equip/Tooling														
Handling/Pre											ĺ			
Material														
Operator														
Offset/Setup														
Process														
Supplier			1											
Training											,			
Transport														
Unapproved				<u> </u>			<u> </u>					<u> </u>		
				*			FA	ULT CA	TEGORY				· · · - · · ·	
Landi	ng (				_	General	_	le . 1: . 75	\	Г			Pressure	/Farand
		Bending			-	Bend	┝	1	Program	}	Outside Dim			rorcea
		Centre No	ot Concer	ntric	-	BOM/Route	-	Grain		}	Over/Under Part Incorre	1	Set-up	ture/Cure
	_	Cracks	- /D:   -	/\A1=	-	Broken/Damage/Defect	-	Hardwa		avalified	Part Lost/M	i i	Weld	ture/Cure
l I		Crimp/Kii	пк/кірріе	/ wave		Burrs	-	1	ion Incomplete/Un		Part Moved	_		ock Pulled
	-	Cuffs Crushing			-	Contamination Countersink		4	tions Incomplete/U gned/off center	inclear	Positioned \		wrong 30	OCK FUIICU
	$\vdash$	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe	=	ŀ	Power Loss,	· ·	Other	
	<u> </u>	Inspectio		Tubo	-	Drawing	-	Misrea		į.		Juige	Totalet	
	$\vdash$	Marks/Ch	•	iube	}	Drill Holes	$\vdash$	Off-set			<u> </u>	· · · · · · · · · · · · · · · · · · ·		_
	-	1	Sequence			Finish	-	4	Calibration					
	-	Wave/Tw				Fit/Function	$\vdash$	4	Sequence					
1	ı			-		1	1	1						

Work Ord September-11-1				*194	1211*						Page 3
Item ID: Revision ID: Item Name:	D3512-1 Stainless Ste	el Wearplate		Accept	*N900	040	100	)*	Setup Sta	! /	S1* S2*
Start Date: Required Date: Reference:	9/10/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1 Customer:	ID:				1.0	17
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		]	Run Sta Sta	<b>/  ^   </b>	R1* R2*
Sequence ID/ Work Center II 150  *150* Packaging Packaging	D	Operation Description Identify as per dwg & Stoc	k Location: <u>SF6</u> 77	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty  12	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

160

\*160\*

Quality Control

MLJ 14-10-01 THF 14-9-30

DQA:			Date:						_				DART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFOI	RMANCE / UP		/ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
Work Orde	- . No.				·	Rework Scrap Use-as-is			Skid-tube  Machining  noforming	Crosstube Small Fab Finishing	<b>⊸</b> i	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	۱٥.					Suspected Unapproved	J		Large Fab	Composite		Supplier	
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance	1	Initial nief Eng	Acti Descri		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FA	ULT CA	TEGORY				·············
Landi		Bending Centre N Cracks Crimp/Ki Cuffs Crushing Heat Trei Inspectio	nk/Ripple at on Strip in	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set	ion Incomplete/Un tions Incomplete/U gned/off center eled d	· ·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		4 -	vist in Tul			Fit/Function		Out of	Sequence				

Page 1

Work Order ID: 124211

\*124211\*

Parent Item:

D3512-1

\*D3512-1\*

Parent Item Name: Stainless Steel Wearplate

**Start Date:** 9/10/14

Required Date: 9/10/14

Start Otv: 6.00

Required Oty: 6.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM

IPP Rev:B Now SS as per Rev B 06-12-15 JLM

IPP Rev:C Rev C dwg 07-12-06 DD

13.12.11 ECN13-619/ REV.D DWG DD VERF:JLM

IPP REV:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	518.4170		2			DAS
*M304S16 304/316 Sheet .063	SGA*								**	4			23 9-89 14-09-72

Location	1	Loc Qty	Loc Code	
MAT020	ı	343.417		
	M127821	71.317		•
	M129449	272.1		129449
TPI		175		
	M129545	175		

DQA:		_	Date:										TOAR	T
						<b>WORK ORDER NON-</b>	·CC	ONFO	RMANCE / UP			_	AEROSP	ACE
QA Closed:			Date:							W	ork Order up	date only		
Manle Ond						DISPOSITION				AGAINST DI	EPARTMENT,	PROCESS		
Work Orde	er: -			<del></del>	[	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering	
Part N	J۵					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	_
	••••	<del> </del>			i	Use-as-is			noforming	Finishing	-	e/Packaging	Other	
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite	]	Supplier		
				,									<del></del>	<u></u> .
Root					Desc	ription of work order update		nitial	Actio		Sign &	., .,.	0010000	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspect	tor
Design ,	_													
Doc/Data	$\square$													
Equip/Tooling			!	:		:					!			
Handling/Pre														
Material	$\vdash$					•			<u> </u>					
Operator	Н													
Offset/Setup	H													
Process	Н													
Supplier	H				İ									
Training Transport														
Unapproved	$\vdash$													
Опарриотеа		Ļ	<u> </u>				FA	ULT CA	TEGORY				· · · · · · · · · · · · · · · · · · ·	
Landi	ng (	Gear				General		<del></del>						
	_	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Force	d
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí	Temperature/C	ure
	Г	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld	
		Cuffs			Г	Contamination		instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pu	ılled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
]		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
1		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning 9	Sequence			Finish		Out of	Calibration					
		Wave/Tv	vist in Tul	be		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	124211
Description: Wearplate	Part Number:	D3512-1
Inspection Dwg: D3512 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	0.375	-		U	Jimos
12.600	+/-0.010	12-400	-		7	Jimos Jimos
0.145	+/-0.010	0.145"	-		V	
0.750	+/-0.010	6.750	_		v	
2.631	+/-0.010	2631	-		V	
2.341	+/-0.010	2.341	-		v	
1.240	+/-0.010	1.240	_		ν	
0.220	+/-0.010	0.211"			V	
0.380	+/-0.010	6383"	_		υ	
0.063	+/-0.010	0.058	<b>—</b> .		,	
						· · · · · · · · · · · · · · · · · · ·
	DAS					

Measured by: 9-89 Audited by: 38 Preliminary Approval:

Date: 14-09-78. Date: 14-5-89 Date:

Rev	Date	Change	Revised by	Approved
Α	07.04.02	New Issue	KJ/JLM	
В	08.01.16	Dimensions updated per Dwg Rev C	KJ/EC/DD A	11
C		Dwg Rev updated	KJ 📥	M







